

AMENDMENTS TO THE CLAIMS

1. (Canceled)
2. (Currently Amended) The method of claim 12 [28], whereby providing heat for the endothermic-blowing agent to absorb occurs before the outer material and the core mixture are injected into the manifold.
3. (Currently Amended) The method of claim 12 [28], whereby providing heat for the endothermic-blowing agent to absorb occurs after the outer material and the core mixture have been injected into the manifold.
4. (Currently Amended) The method of claim 12 [28], whereby providing heat for the endothermic-blowing agent to absorb occurs while the outer material and the core mixture are being controlled through the manifold.
5. (Currently Amended) The method of claim 12 [28], wherein the endothermic-blowing agent comprises a mixture of sodium bicarbonate and sodium hydrogen citrate.
6. (Currently Amended) The method of claim 12 [28], wherein the endothermic-blowing agent includes at least one of aliphatic and halogenated hydrocarbons, low boiling alcohols, ethers, ketones, aromatic hydrocarbons and simple salts.
7. (Presently Presented) The method of claim 6, wherein the endothermic-blowing agent comprises at least one simple salt, and the simple salt comprises at least one of ammonium bicarbonate, sodium bicarbonate and azobisformamide.
- 8-11. (Canceled)

12. (Presently Presented) A method of co-injection molding, the method comprising:
mixing a plastic inner material and an endothermic-blowing agent to form a core mixture;
injecting a plastic outer material from a first injection unit into a co-injection manifold to
create a flow of outer material therethrough;
injecting the core mixture from a second injection unit into the co-injection manifold to
create a flow of core mixture therethrough;
allowing the core mixture to enter the mold cavity only after the outer material enters the
mold cavity, and then allowing the core mixture and the outer material to flow into the mold
cavity concurrently, thereby co-injection molding the core mixture inside the outer material;
stopping the flow of the outer material after the outer material concurrently flows with
the core mixture, thereby allowing the core mixture to remain flowing;
stopping the flow of the core mixture into the mold cavity, and resuming the flow of the
outer material into the mold cavity; and
expanding the core mixture by providing heat for the endothermic-blowing agent to
absorb.

13. (Canceled)

14. (Withdrawn) A co-injected plastic article manufactured by a co-injection process
comprising:
melting an inner material and an endothermic-blowing agent to form a core mixture;
injecting a plastic outer material from a first injection unit through a co-injection
manifold and into a mold cavity;
injecting the core mixture from a second injection unit through the co-injection manifold
and into the mold cavity;
co-injection molding at least a portion of the core mixture inside the outer material in the
mold cavity;
expanding the core mixture by providing heat for the endothermic-blowing agent therein
to absorb; and
allowing the outer material and core mixture to cool in the mold cavity, thereby forming a
co-injected plastic article, wherein about 20.0 to 45.0 percent by volume of the article is inner

material and about 0.1 to 4.0 percent by volume of the inner material is endothermic-blowing agent.

15. (Withdrawn) The article of claim 14, wherein the co-injected plastic article is a steering wheel.

16. (Withdrawn) The article of claim 14, wherein the co-injected plastic article is a hood for a vehicle.

17. (Withdrawn) The article of claim 14, wherein the co-injected plastic article is a toilet seat.

18. (Withdrawn) The article of claim 14, wherein the co-injected plastic article is lawn furniture.

19. (Withdrawn) The article of claim 14, whereby the method by which the article is made further comprises allowing the core mixture to enter the mold cavity only after the outer material enters the mold cavity, and thereafter allowing the core mixture and the outer material to flow concurrently into the mold cavity.

20. (Withdrawn) The article of claim 14, whereby the method by which the article is made further comprises allowing the core mixture to enter the mold cavity before allowing the core mixture to enter the mold cavity, stopping the outer material from entering the mold cavity, allowing the core mixture to enter the mold cavity thereafter, stopping the flow of the core mixture thereafter, and resuming the flow of the core mixture into the mold cavity.

21-28. (Canceled)

29. (New) The method of claim 12, wherein the inner material and the blowing agent are exposed to a temperature between about 300 to 600 °F and a pressure between about 5,000 to 25,000 PSI to form the core mixture.

30. (New) The method of claim 12, wherein the blowing agent is about 0.5 to 3.0 percent by volume of the inner material.

31. (New) The method of claim 12, wherein the blowing agent is about 1.0 to 2.0 percent by volume of the inner material.